

slp Jan 31

Work Order ID 79382

\*79382\*

Page 1

Wednesday, January 25, 2012 11:48:48 AM

Item ID: D4435-045 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: T/R Bellcrank Cover Assembly  
 Start Date: 1/25/2012 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 2/3/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: PL Date: 12/01/2011 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4435	A

100 0.00  
 \*100\*  
 Small Fab Memo 0.00  
 Small Fab assemble as per dwg

*Handwritten signature* 12/01/31 (2)

110 0.00  
 \*110\*  
 QC Memo 0.00  
 Quality Control

*Handwritten* 8/12/12/31

*Handwritten circled P*

120 0.00  
 \*120\*  
 Powdercoat Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00  
 Powder Coating

Memo  
 START TIME: 11:45  
 OVEN TEMPERATURE: 320 °F  
 FINISH TIME: 12:15

*Handwritten signature* 12/01/31

*Handwritten* M115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <i>SM 110</i>	0.00							
<b>*140*</b>									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

*2/12/12-31*

*12/1/13*

*12/1/31*

*12-01-31*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Wednesday, January 25, 2012 11:48:53 AM

Page 1

Work Order ID: 79382

**\*79382\***

Parent Item: D4435-045

**\*D4435-045\***

Parent Item Name: T/R Bellcrank Cover Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevB 11.12.22 per PA2 EC verified by:JLM  
12.01.23 per REVA DD verified by:EC

IPP RevC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4435-5		Manufactured	No			100	Each	3.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**\*D4435-5\***

Mount Bracket

Location

Loc Qty

Loc Code

ENG

3

B79373

74754

2

77911

1

D4435-7		Manufactured	No			100	Each	2.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**\*D4435-7\***

Bracket

Location

Loc Qty

Loc Code

prelim

2

B79374

74757

2

MS20426AD3-2		Purchased	No			100	Each	18,319.00	4	4			
--------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--

**\*MS20426AD3-2\***

Rivet

Location

Loc Qty

Loc Code

Mezz

18319

1173

8919

13276

9400

MS20470AD4-3		Purchased	No			100	Each	5,950.000	4	4			
--------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	--	--

**\*MS20470AD4-3\***

Rivet - Universal Head

Location

Loc Qty

Loc Code

Mezz

5950

1642

1316

2193

4634

SS 12/01/31

2

SS 12/01/31

2

SS 12/01/30

M119109 (84)

PTO

SS 12/01/30

PTO

W/O: 79382		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
1201-29		Change rivets to 3-3  Permanent Change		1201-29	1			
		No PERMANENT CHANGES. RIVET LEIGHT WAS DEQUATE W PREVIOUS Rivets. 120206						

Part No: D4435-045 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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\*79382\*

Parent Item: D4435-045

\*D4435-045\*

Parent Item Name: T/R Bellcrank Cover Assembly

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 1.00

Required Qty: 1.00

MS21059L3

Purchased

No

100

Each

323.0000

1

1

\*MS21059L3\*

Nut Plate

\*\*

12/01/30

Location

Loc Qty

Loc Code

ST301

123

118614

23

119546

100

ST302

200

120308

200

MS21062L3

Purchased

No

100

Each

0.0000

1

1

\*MS21062L3\*

Nut Plate

\*\*

M 120498

⑦

12/01/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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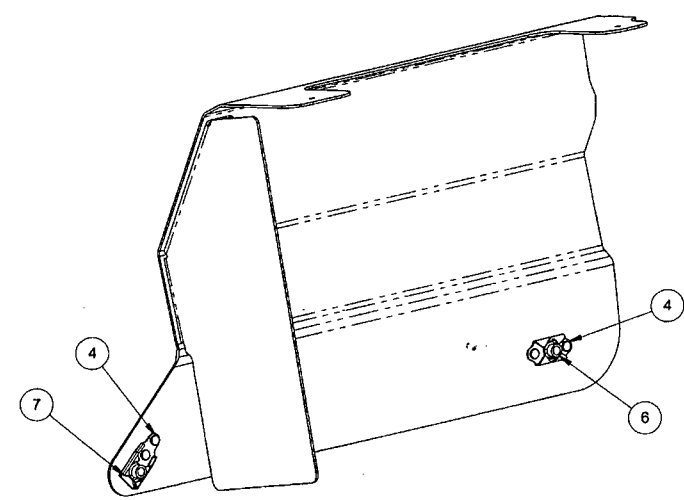
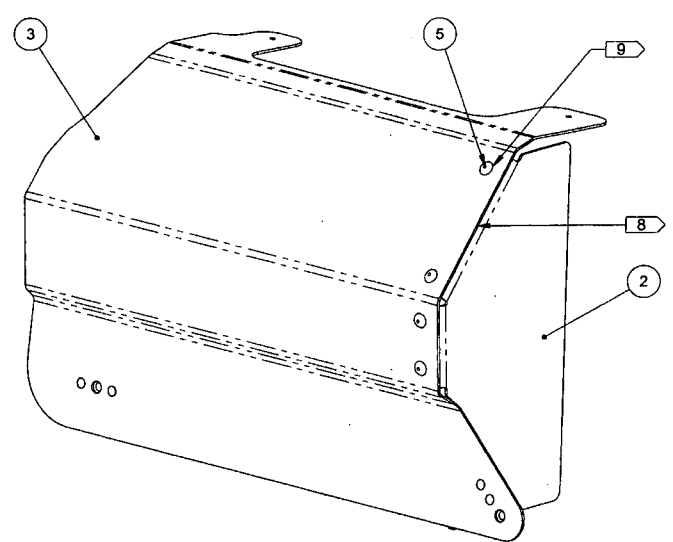
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SHOP COPY  
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 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 29382  
 12-01-25

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	1	D4435-5	MOUNT BRACKET
3	1	D4435-7	BRACKET
4	4	MS20426AD3-2	RIVET
5	4	MS20470AD4-3	RIVET
6	1	MS21059L3	NUT PLATE
7	1	MS21062L3	NUT PLATE



**D4435-045 T/R BELLCRANK COVER ASSEMBLY**

RELEASED  
 2012-01-23  
 [Signature]

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "BLACK SANDETEX" (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.372 lbs
  - 8) INSTALL D4435-5 BRACKET SURFACE FLUSH WITH THIS EDGE
  - 9) TRANSFER Ø0.129 HOLES FROM D4435-5 MOUNT BRACKET INTO D4435-7 BRACKET

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	[Signature]	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D4435	SHEET 3 OF 11
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	BRACKET	NTS
DATE	12.01.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

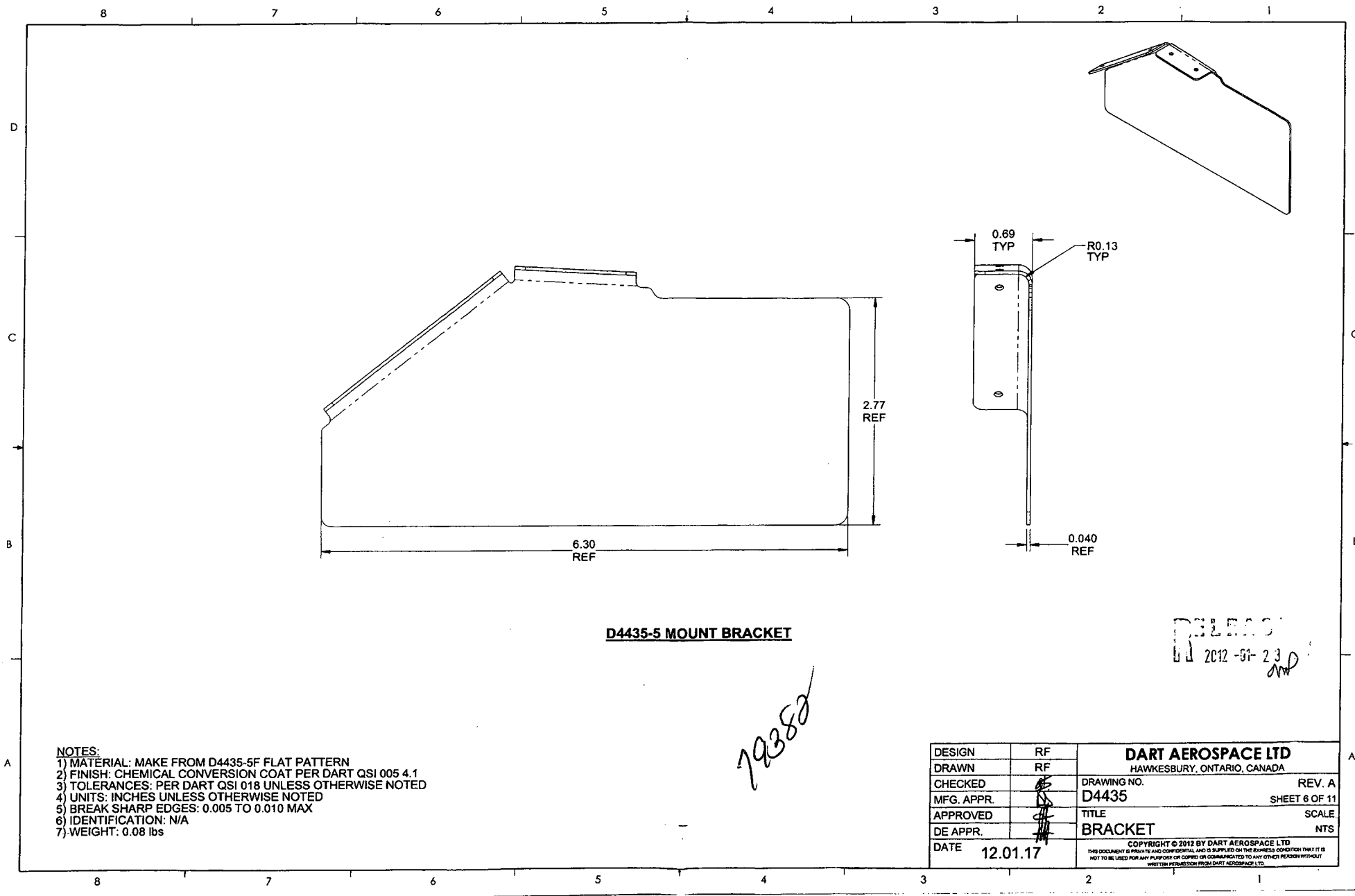
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**D4435-5 MOUNT BRACKET**

RELEASED  
2012-01-23

79380

**NOTES:**

- 1) MATERIAL: MAKE FROM D4435-5F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4435</b>	SHEET 6 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BRACKET</b>	NTS
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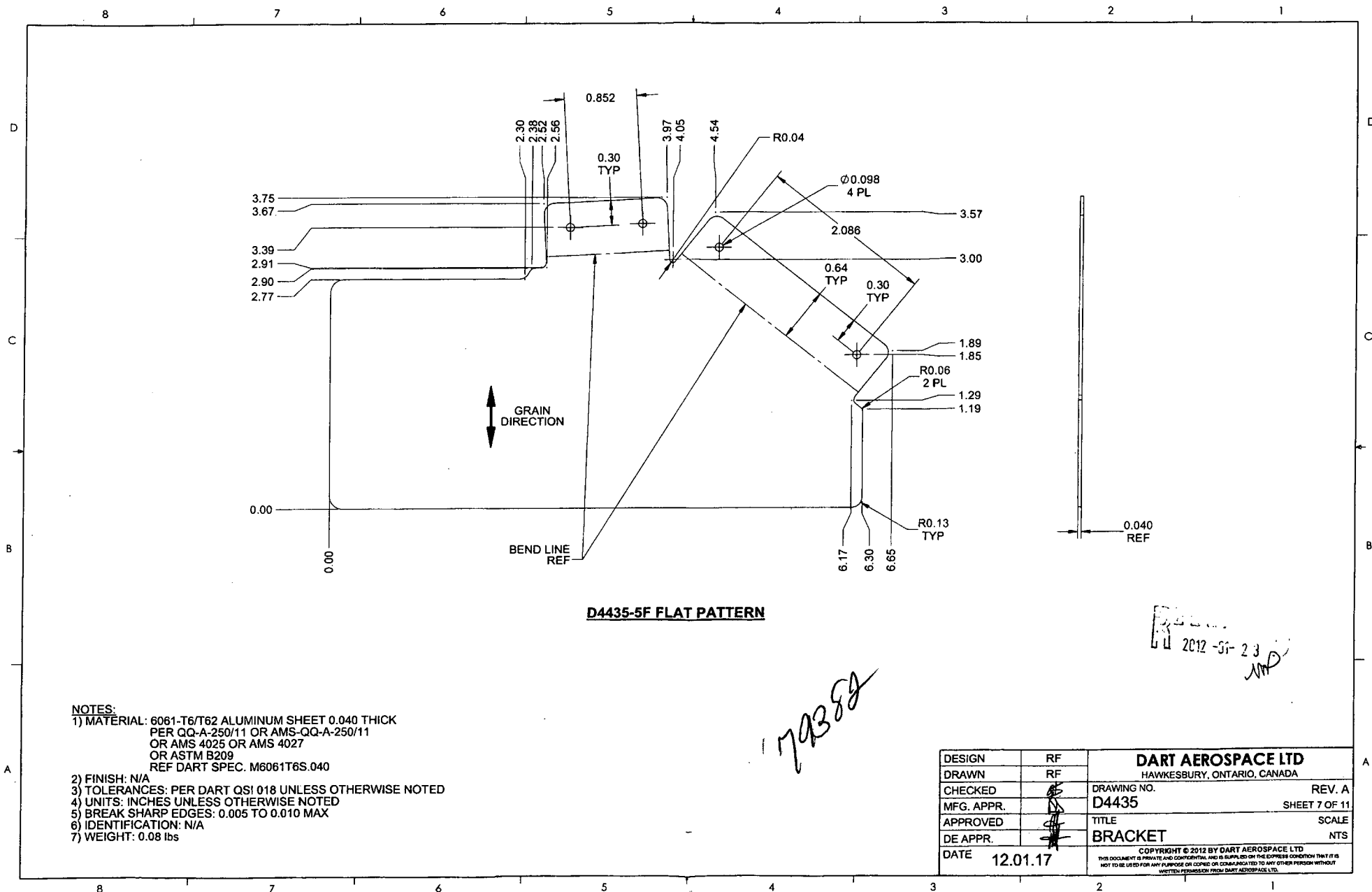
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